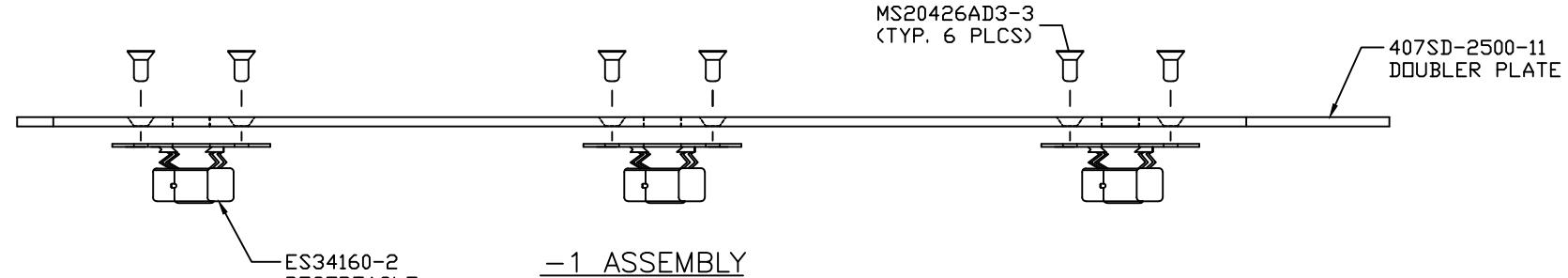
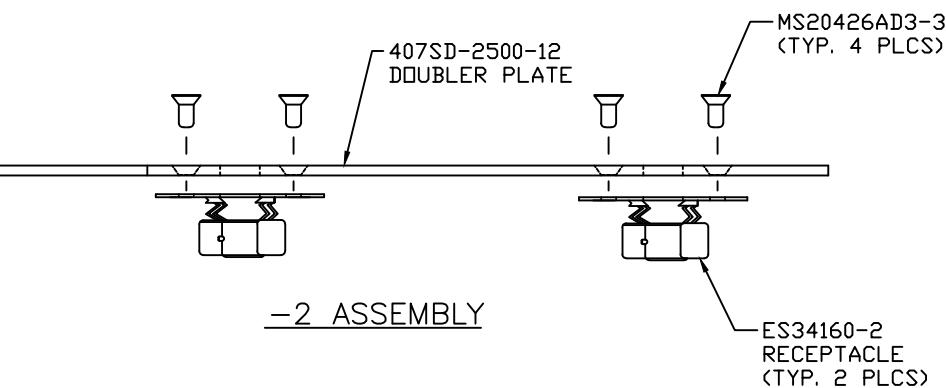


SHEET	REV	ECO	DATE	DESCRIPTION	BY	CHK	APR
1-4	A		02/26/01	REDIMENSIONED -11, -12, & -13 PARTS	MR	LS	MR
1	B		10/17/06	BOM CORRECTED: SHOWED -11 IN -3, -13 IN -1, SHOWED R35 QTY 1 IN -1, QTY 3 IN -3, MS20426AD3-3 QTY 2 IN -1, QTY 6 IN -3.	REB	LS	REB
1-4		1	04/09/08	ADDED W X L TO STOCKS, (X,Y) COORD'S & NOTE 1. ADDED (REF) TO HOLE ANGLES. REMOVED INNER & OUTER RADII. OVERALL LENGTHS WERE REF'D. -11: 8.84 WAS 9.37, 78° WAS 86°.	REB	LS	REB
1-8	C		09/25/13	ADDED -14, -15 & -16 PARTS. ADDED -4, -5 & -6 ASSY.	JJT	LS	JJT
7	D		01/06/14	CHANGED LAYOUT OF -15 FOR EASE OF INSPECTION. MODIFIED MIDDLE HOLE LOCATION OF -15, WAS 4.227, 0.638. ROTATED RECEPABLE HOLES ON RIGHT, WAS 16 DEGREES.	JJT	LS	JJT
8	E		12/18/15	SHT. 7 -15 REMOVED .467 DIM & ADDED .884-.854 DIM, SHT. 8 -16 REMOVED '1.55 X 7.60" FROM STOCK NOTES.	JT	LS	JT
3-8	F		05/30/19	ADDED DETAIL A TO SHTS 3-8; ADDED DETAIL B TO SHT 6	DT	LS	ZA
1-2,6-8	G		05/11/21	R35 NOW ES34160-2, SHT 2: ADDED P/N CALLOUTS; SHT 6-8: ADDED DIMENSIONS TO UNDEFINED FEATURES;	DT	LS	ZA



-1 ASSEMBLY



	2			NAS1399C3-3	RIVET (ALT. CR2662-3-03)
	2			NAS1149FN232P	WASHER
	1			ES34160-1	RECEPTACLE
4	3	2	1	2	3
8	6	4		ES34160-2	RECEPTACLE (ALT. R35 (CLASS B))
			2	MS20427M3-3	RIVET (ALT. MS20426T3-3)
			4	MS20426AD3-3	RIVET
			6		
				1	407SD-2500-11
					DOUBLER PLATE
				1	407SD-2500-12
					DOUBLER PLATE
				1	407SD-2500-13
					DOUBLER PLATE
				1	407SD-2500-14
					DOUBLER PLATE
				1	407SD-2500-15
					DOUBLER PLATE
				1	407SD-2500-16
					DOUBLER PLATE
-6	-5	-4	-3	-2	PART NUMBER
ASSY	ASSY	ASSY	ASSY	ASSY	DESCRIPTION
QTY	QTY	QTY	QTY	QTY	

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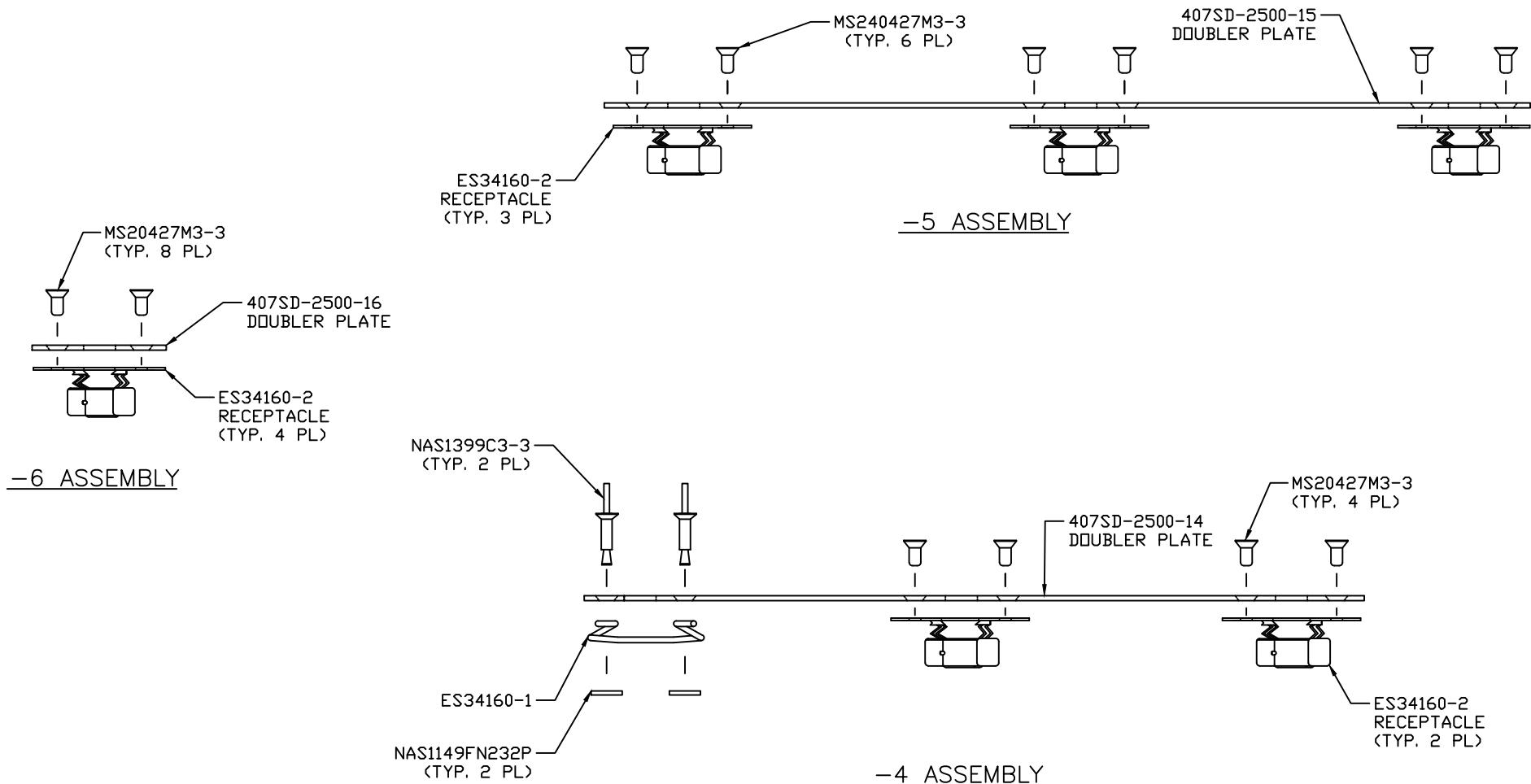
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PROTO

N/C

Paravion® Technology		TITLE		DRAWING NO.	
		DOUBLER ASSEMBLY		407SD-2500	
DRAWN BY	APRVD. BY	CHK'D BY	DATE	REV	ECO
KRG	PR	LS	10/27/99		
DO NOT SCALE DRAWING					SHEET
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BREAK ALL SHARP EDGES



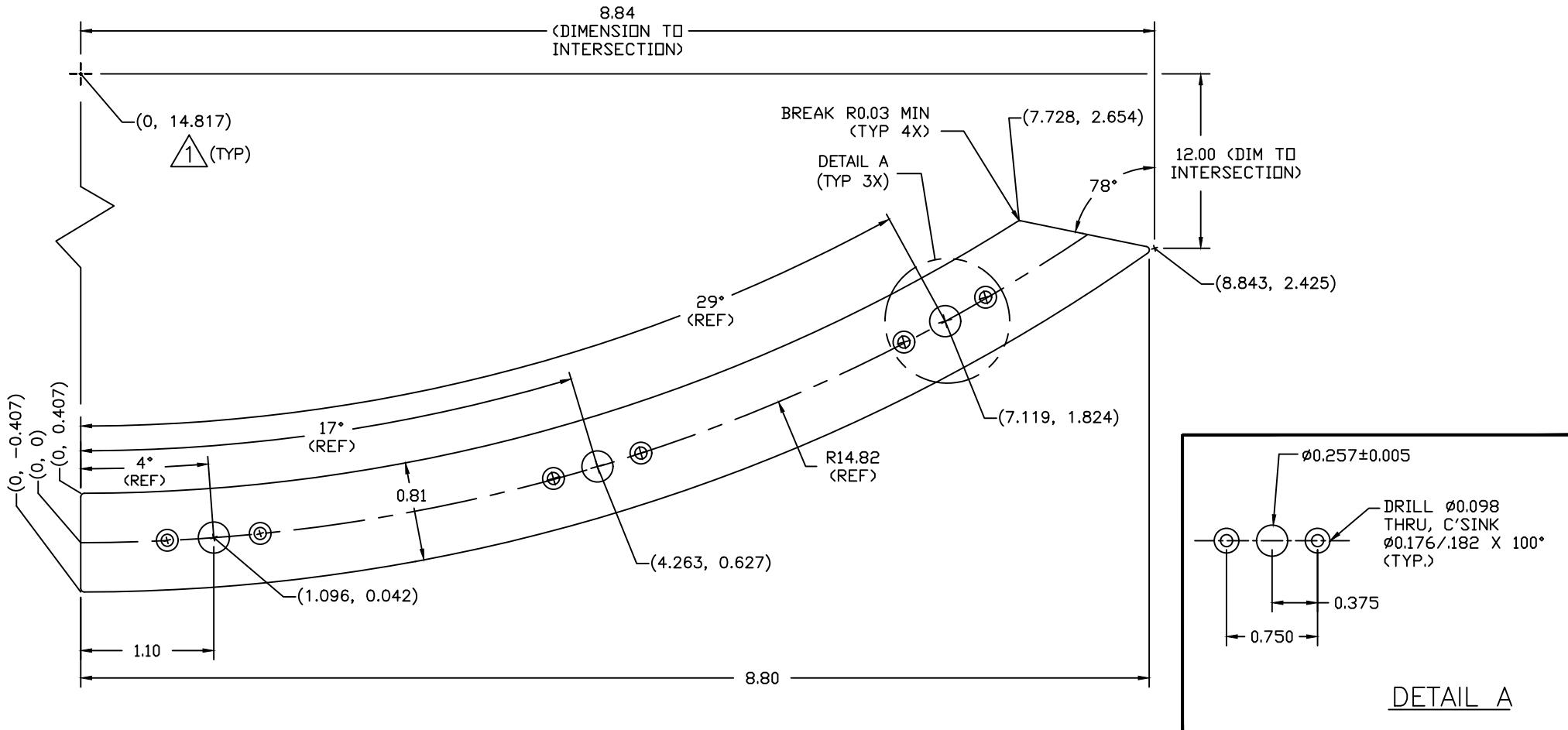
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Paravion® Inc. Technology		TITLE DOUBLER ASSEMBLY			DRAWING NO. 407SD-2500				
DIMENSIONS IN INCHES		TOLERANCES EXCEPT WHERE NOTED:							
DRAWN BY	APRV'D. BY	CHK'D. BY	DATE		REV	ECO			
KRG	PR	LS	10/27/99		G				
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PROTO	N/C	INTERNAL=CLASS 2B EXTERNAL=CLASS 2A							

MATERIAL: 6061-T6 AL, PER QQ-A-250/11 OR AMS 4027
 STOCK: 0.063 SHEET, 1.55 X 9.95
 FINISH: BLACK ANODIZE PER MIL-A-8625 TYPE II, CLASS 2, BLACK
 SURFACE FINISH 125\AA

1 COORDINATE POINTS (REF) FOR MACHINE SET-UP.



-11 DOUBLER PLATE

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DRAWN BY	APRVD. BY	CHK'D BY	DATE	REV	ECO		
KRG	PR	LS	10/27/99				
DO NOT SCALE DRAWING						SHEET	3 OF 8
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PROTO

N/C

ANGLES = $\pm 1^\circ$

THREADS:

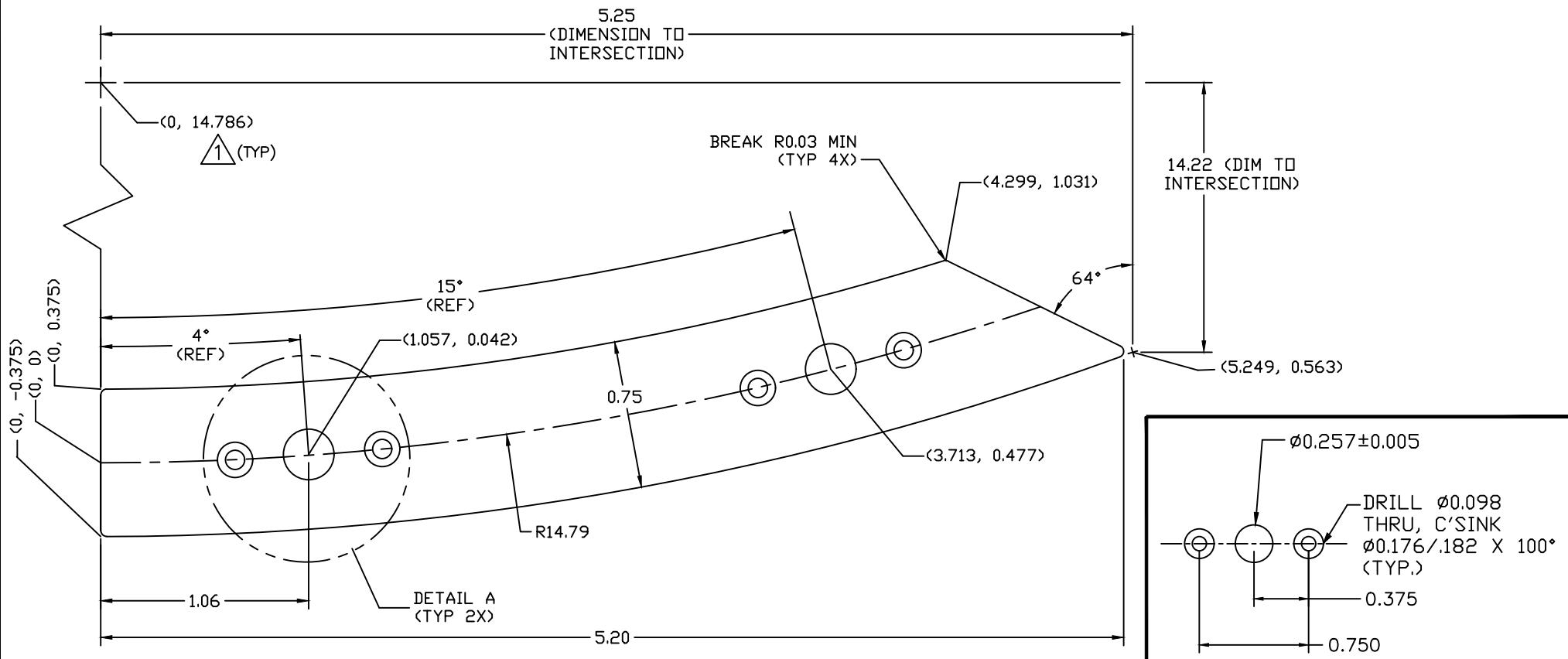
INTERNAL=CLASS 2B

EXTERNAL=CLASS 2A

MATERIAL: 6061-T6 AL, PER QQ-A-250/11 OR AMS 4027

STOCK: 0.063 SHEET, 1.02 X 5.40

FINISH: BLACK ANODIZE PER MIL-A-8625 TYPE II, CLASS 2, BLACK

SURFACE FINISH $125\text{ }\mu\text{m}$ 

-12 DOUBLER PLATE

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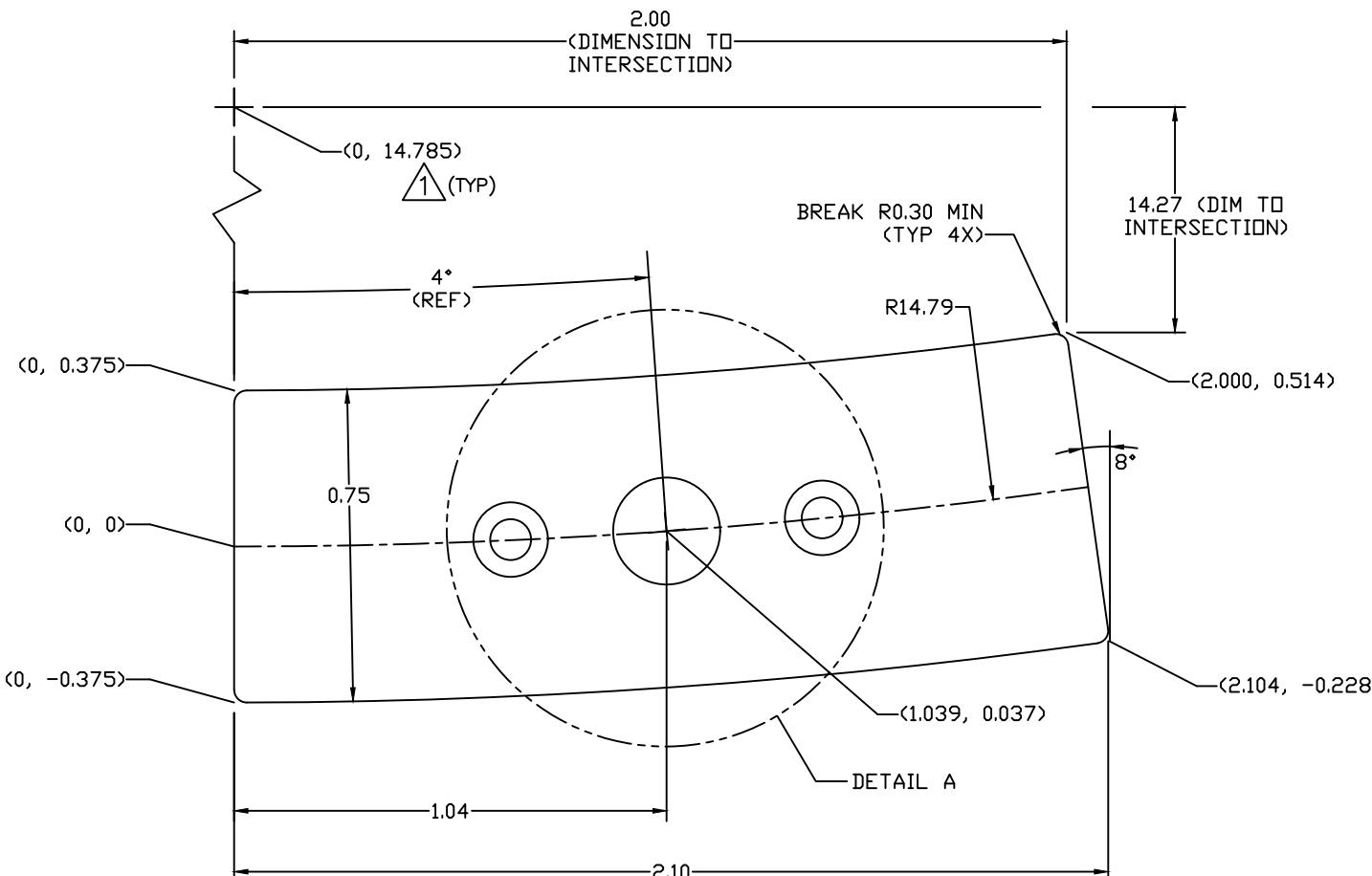
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DIMENSIONS IN INCHES		DRAWN BY	APRVD. BY	CHK'D BY	DATE	REV	ECO
PROTO	N/C	KRG	PR	LS	10/27/99	G	
DO NOT SCALE DRAWING						SHEET 4 OF 8	
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MATERIAL: 6061-T6 AL, PER QQ-A-250/11 OR AMS 402

STOCK: 0.063 SHEET, 0.90 X 2.21

FINISH: BLACK ANODIZE PER MIL-A-8625 TYPE II, CLASS 2, BLACK

SURFACE FINISH 125



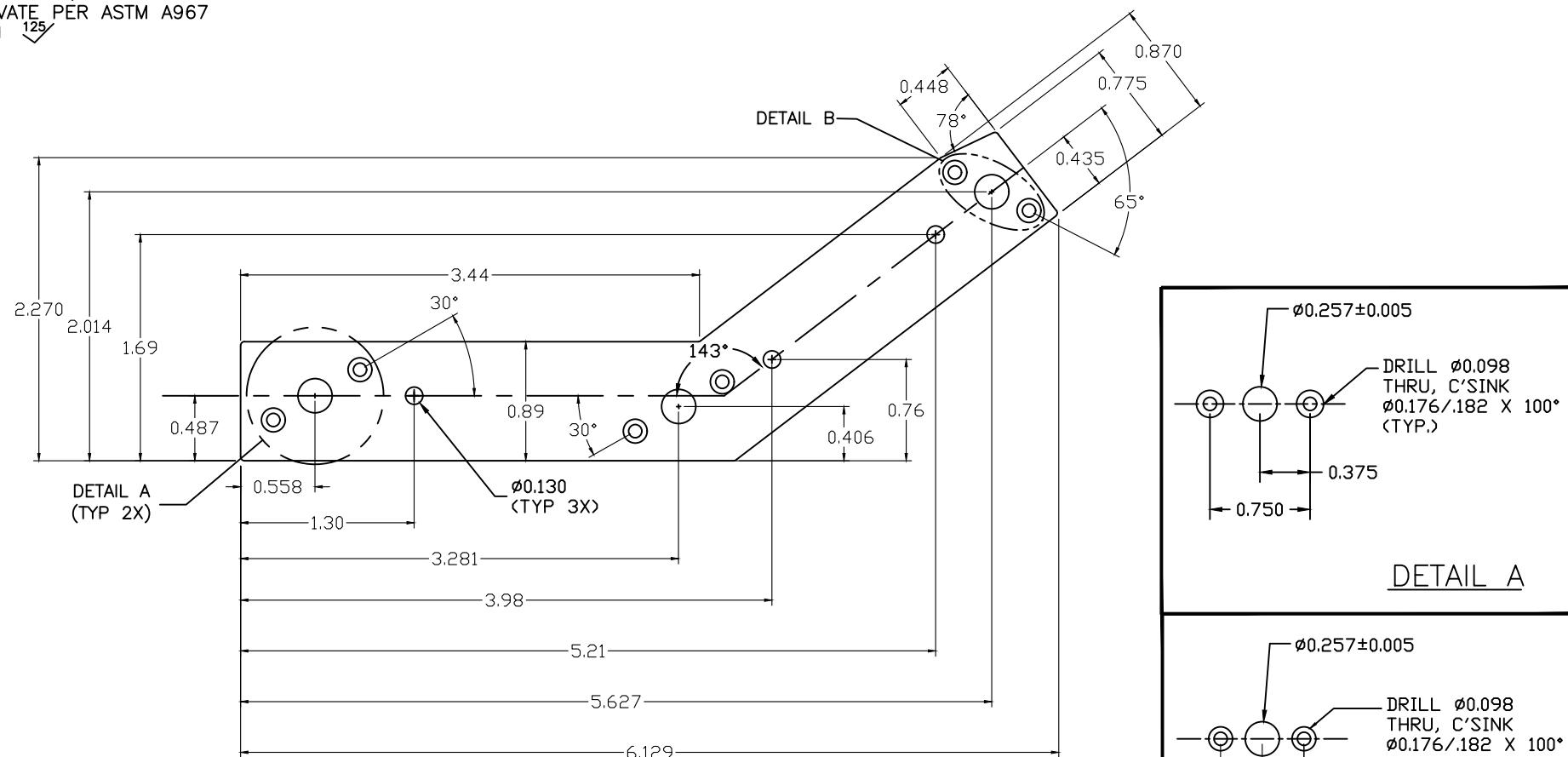
-13 DOUBLER PLATE

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	DRAWN BY KRG	APRVD BY PR	CHK'D BY LS	DATE 10/27/99	REV G	ECO
DO NOT SCALE DRAWING						SHEET 5 0F 8
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MATERIAL: 304 STAINLESS STEEL PER AMS 5513; ALT AISI 316 SS PER AMS 5524
 STOCK: 0.040 SHEET, 2.40 X 7.50
 FINISH: PASSIVATE PER ASTM A967
 SURFACE FINISH $\sqrt{125}$



-14 DOUBLER PLATE

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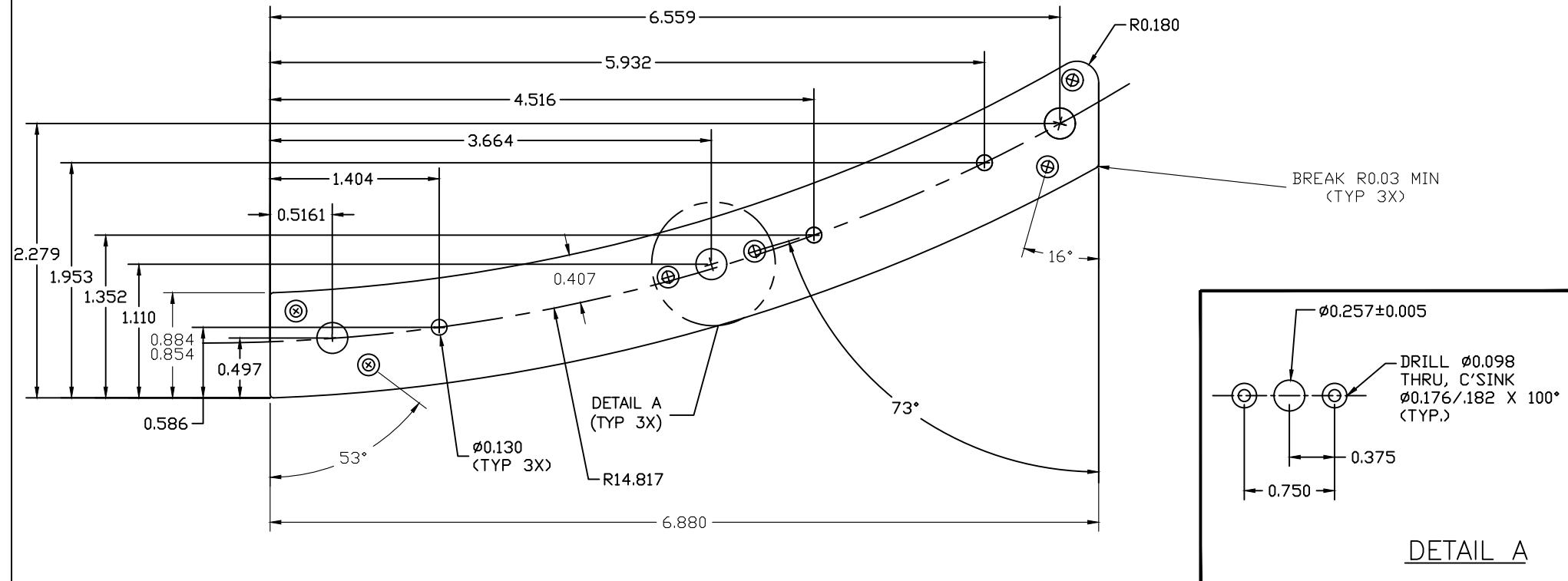
Paravion® Inc. Technology		TITLE DOUBLER ASSEMBLY		DRAWING NO. 407SD-2500	
DRAWN BY	APRVD. BY	CHK'D BY	DATE	REV	ECO
KRG	PR	LS	10/27/99	G	
DO NOT SCALE DRAWING					
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PROTO

N/C

INTERNAL=CLASS 2B
EXTERNAL=CLASS 2A

MATERIAL: 304 STAINLESS STEEL PER AMS 5513; ALT AISI 316 SS PER AMS 5524
 STOCK: 0.040 SHEET, 3.30 X 9.10
 FINISH: PASSIVATE PER ASTM A967
 SURFACE FINISH $\frac{125}{\mu\text{m}}$



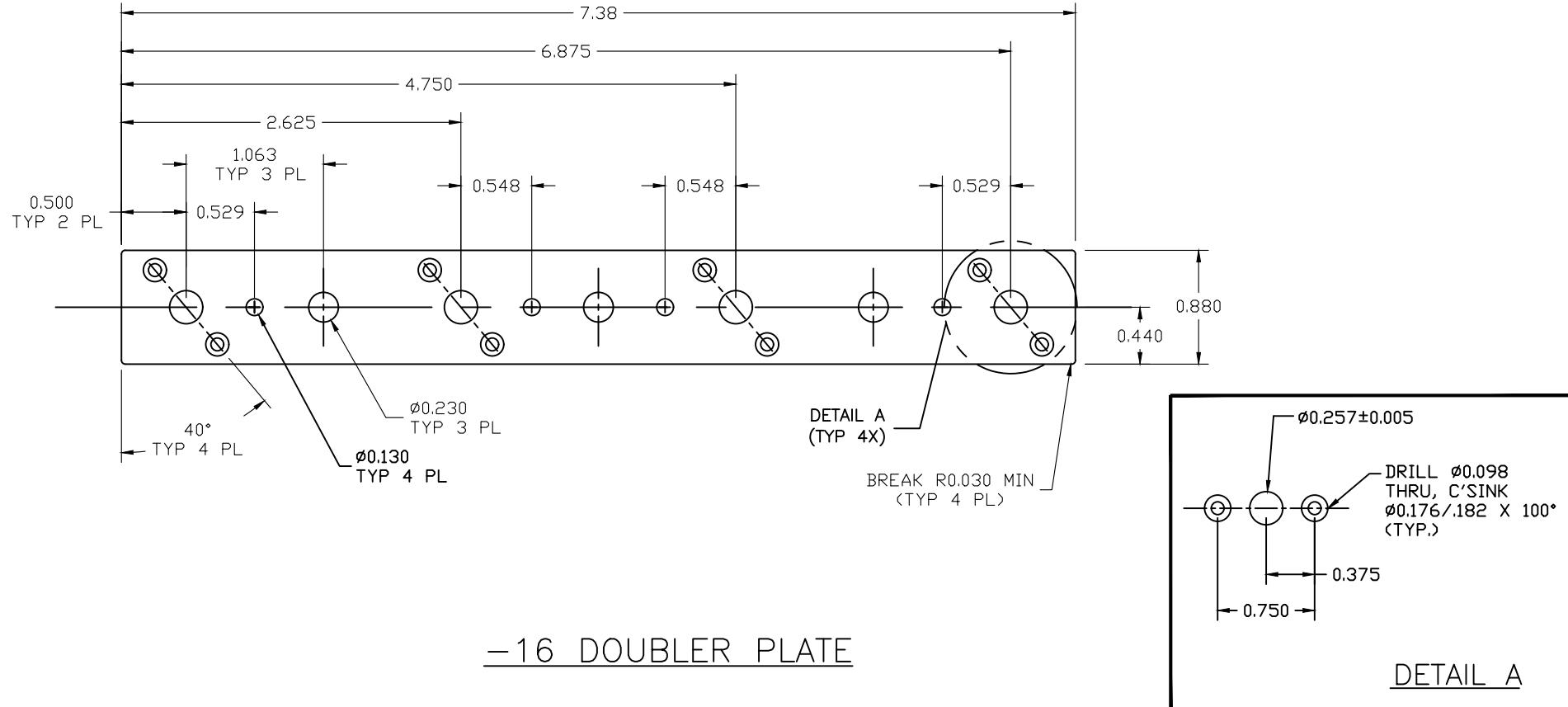
-15 DOUBLER PLATE

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Paravion® Inc. Technology		TITLE DOUBLER ASSEMBLY		DRAWING NO. 407SD-2500	
DIMENSIONS IN INCHES					
TOLERANCES EXCEPT WHERE NOTED: .X = $\pm .1$.XX = $\pm .05$.XXX = $\pm .010$ ANGLES = $\pm 1^\circ$ THREADS: INTERNAL=CLASS 2B EXTERNAL=CLASS 2A					DO NOT SCALE DRAWING
DRAWN BY KRG	APRVD BY PR	CHK'D BY LS	DATE 10/27/99	REV G	SHEET 7 OF 8
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MATERIAL: 304 STAINLESS STEEL PER AMS 5513; ALT AISI 316 SS PER AMS 5524
 STOCK: 0.040 SHEET
 FINISH: PASSIVATE PER ASTM A967
 SURFACE FINISH $125\text{ }\mu\text{m}$



Paravion® Inc. Technology		TITLE DOUBLER ASSEMBLY		DRAWING NO. 407SD-2500									
DIMENSIONS IN INCHES		TOLERANCES EXCEPT WHERE NOTED:		DRAWN BY		APRV'D. BY	CHK'D. BY	DATE		REV G	ECO		
PROTO	KRG	PR	LS	10/27/99		DO NOT SCALE DRAWING							
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SHEET
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